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D2842-041

Job Sheet 204144



Part No: D2842-041

Job Qty: 3 pcs

Part Name: Step Assembly, LH, 206 Float



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/3/19

Job Tracking No:

Due Date: 1/7/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev:D As Per Ecn 766 06-01-06 JLM

Ship Via:

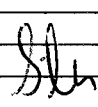
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Steps - 1	3 pcs	1/7/20	1/7/20	0.00	4.41	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 5	3 pcs	1/7/20	1/7/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
								DAS	
								DEC 17 2019	68
								QC 5 - 9	9-89
								QC 5 - 50	
								QC 5 - 30	
								QC 5 - 40	
								QC 5 - 61	
								QC 5 - 81	

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120 Large Fab - Steps - 2 - B4B	3 pcs	1/7/20	0.00 4.41	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	12
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
130 QC 9	3 pcs	1/7/20	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	DAS
				QC 9 - 43	24
				QC 9 - 50	9-89
				QC 9 - 9	
140 QC 5	3 pcs	1/7/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	DAS
				QC 5 - 43	24
				QC 5 - 49	9-89
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Handfinish - 1-1 Chemical-B4B	3 pcs	1/7/20	0.00 1.11	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	SA JAN 06 2020
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	

				Handfinish - 1 - 22 - B4B	
160 QC 7	3 pcs	1/7/20	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	DAS JAN 07 2020 68
				QC 7 - 50	9-89
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
170 Large Fab - Steps - 3 - B4B	3 pcs	1/7/20	0.00 4.41	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
180 QC 10	3 pcs	1/7/20	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	DAS
				QC 10 - 50	24
				QC 10 - 58	9-89
				QC 10 - 9	
				QC 10 - 68	
190 QC 5	3 pcs	1/7/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	DAS
				QC 5 - 18	24
				QC 5 - 19	9-89

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				QC 5 - 22	DAS	
				QC 5 - 24	24	
				QC 5 - 3	9-89	
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
191 Handfinish - 2-1 Pressure-B4B	3 pcs	1/7/20	0.00 1.11	Handfinish - 2 - 1 - B4B		
				Handfinish - 2 - 2 - B4B		ST JAN 08 2020
				Handfinish - 2 - 3 - B4B		
				Handfinish - 2 - 4 - B4B		
200 Powdercoat - 1 White Gl(A)-B4B	3 pcs	1/7/20	0.00 0.72	Powdercoat - 1 - B4B		
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		BL 20-01-18
				Powdercoat - 4 - B4B		
210 QC 3	3 pcs	1/7/20	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		ML 20-1-14
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		
				QC 3 - 43		
				QC 3 - 24		
				QC 3 - 61		
				QC 3 - 81		
220 Handfinish - 4-1-Assembly-B4B	3 pcs	1/7/20	0.00 1.11	Handfinish - 4 - 1 - B4B		ML 20-1-14
				Handfinish - 4 - 10 - B4B		
				Handfinish - 4 - 11 - B4B		
				Handfinish - 4 - 12 - B4B		
				Handfinish - 4 - 13 - B4B		
				Handfinish - 4 - 14 - B4B		
				Handfinish - 4 - 15 - B4B		
				Handfinish - 4 - 2 - B4B		
				Handfinish - 4 - 3 - B4B		
				Handfinish - 4 - 4 - B4B		
				Handfinish - 4 - 5 - B4B		
				Handfinish - 4 - 6 - B4B		
				Handfinish - 4 - 7 - B4B		
				Handfinish - 4 - 8 - B4B		

DAS
15
9-89

230 QC 5	3 pcs	1/7/20	0.00 0.00	Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	DAS
				QC 5 - 40	81
				QC 5 - 61	9-89
				QC 5 - 81	JAN 22 2020
240 Packaging 3-1 - Stock - B4B	3 pcs	1/7/20	0.00 0.00	Packaging 3 - 1 - B4B	F.D JRB
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
250 QC 21 - SA	3 pcs	1/7/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	JAN 27 2020

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FG107

Part Op 100 - (Fabricate per Dwg) 1-Cut D2842-1 using D2622 extrusion as per Dwg D2842 2-Drill D2842-1 using Jig DT8271 as
 Descriptions: per Dwg D2842 ***DO NOT OPEN HOLES*** 3-Debur and bevel ends for welding
 110 - (QC5- Inspect part completeness to step on W/O)
 120 - (Weld per dwg A/R Aluminum rod Batch: 139989) 1-Weld one end cap and (2) lugs using Jig DT10038 as per Dwg
 D2842 2-Grind end cap weld flush 3- Open hole as per dwg and deburr(0.250")
 130 - (QC9- Inspect visual per QSI004- Fusion Welds)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - (Weld per dwg A/R Aluminum rod Batch:) 1-Remove alodine prior to welding. Weld end cap as per Dwg
 D2842. 2-Grind end cap weld flush.
 180 - (QC10- Inspect visual per QSI004- ground welds)
 190 - (QC5- Inspect part completeness to step on W/O)
 191 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)***Touch up step with alodine per qsi 005 prior to
 powder coat***
 200 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 9:55 M 235590 OVEN TEMPERATURE: 300°
 FINISH TIME: 10:25
 210 - (QC3- Inspect Part Finish)
 220 - (Assemble as per dwg) 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1
 Batch: 5240160
 230 - QC5- Inspect part completeness to step on W/O)
 240 - (Identify as per dwg & Stock Location:)
 250 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	3 pcs (1 ea)	100-Large Fab - Steps - 1	5221766
D2734	Step End Plate	3 pcs (1 ea)	100-Large Fab - Steps - 1	5225431
D2734	Step End Plate	3 pcs (1 ea)	100-Large Fab - Steps - 1	5225431
D3459-1	Float Step Mounting Plate	6 pcs (2 ea)	100-Large Fab - Steps - 1	5241255
D3459-3	Float Step Mounting Plate	6 pcs (2 ea)	100-Large Fab - Steps - 1	1x5094853/5x5241312
MS27039C1-07	Screw	9 Ea (3 ea)	220-Handfinish - 4-1-Assembly-B4B	511132312-10
NAS1149C0332R	Washer (AN960C10L)	9 Ea (3 ea)	220-Handfinish - 4-1-Assembly-B4B	5233308
NAS1329C3KB130	Insert	9 Ea (3 ea)	220-Handfinish - 4-1-Assembly-B4B	P0638537
NAS1515H3L	Washer	9 Ea (3 ea)	220-Handfinish - 4-1-Assembly-B4B	5214621

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	3	44	0
	D2734	6	23	0
	D3459-1	6	4	0
	D3459-3	6	5	0
	MS27039C1-07	9	18	0
220-Handfinish - 4-1-Assembly-B4B	NAS1149C0332R	9	4,438	0
	NAS1329C3KB130	9	57	0
	NAS1515H3L	9	254	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					